

Date: Thursday, 24/05/2007 1:57:13 PM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEB
Job Number	32582	Part Number	D2739
Estimate Number	10498	Drawing Number	D2739 REV C
P.O. Number	N/A	Project Number	N/A
This Issue	24/05/2007	Type	LANDING GEAR
Prsh Rev.	NC	Drawing Revision	C
First Issue	N/A	Material	N/A
Previous Run	32282	Due Date	31/05/2007
Written By		Qty:	8
Checked & Approved By		Um:	Each
Comment	Est Rev: C 02.11.28 Rerformat KJ Est Rev: D 06-03-21 As Per Rev C JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)	
	Extrusion 'I Beam' thin	
	Pick:	
	Qty Part Number Description Batch	
	1 D2600-5 Web 029985	
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
	Comment: LANDING GEAR RESOURCE 1	
	1-Cut D2600-5 to length as per Dwg D2739.	
	2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739	
	3-Use uni-bit to open holes to finish size as per Dwg D2739.	
	4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends.	
	5-Dburr	
3.0	QC5	INSPECT WORK TO CURRENT STEP
	Comment: INSPECT WORK TO CURRENT STEP	
		7-5-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 07/06/01
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 24/05/2007 1:57:14 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 32582

Part Number: D2739

Job Number:



Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	31 JD 7-5- 31
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		 DP 7-5-31
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	
6.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.	31 JD 7-5- 31
	Identify and Stock Location: L6	
7.0	QC21	FINAL INSPECTION/W/O RELEASE
		 31 207106/01
	Comment: FINAL INSPECTION/W/O RELEASE	

Job Completion



207105131

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

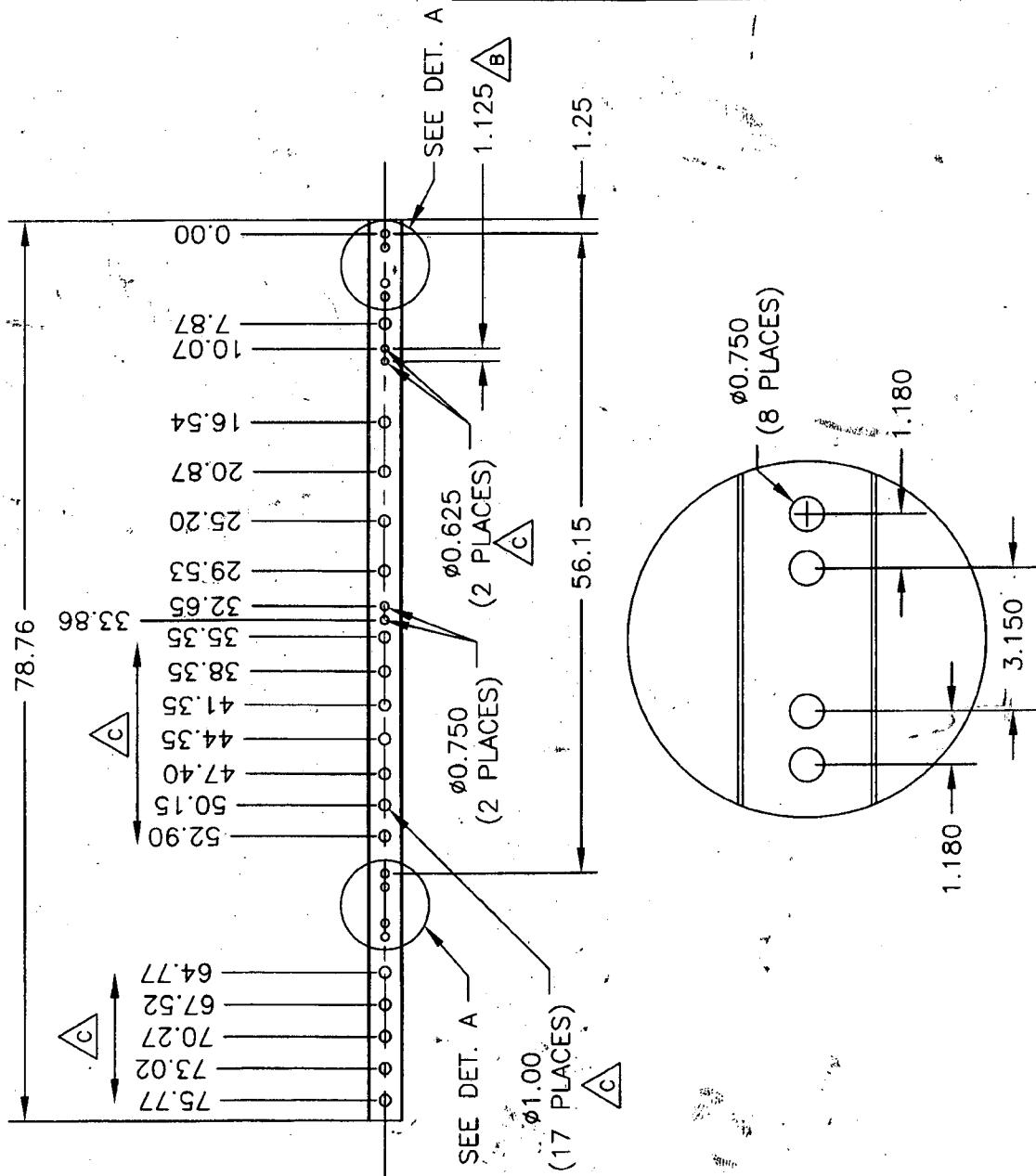
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action: Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description: Chief Eng			

NOTE: Date & initial all entries

DART

DESIGN RH	DRAWN BY RH	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	DRAWING NO.	PORT HADLOCK, WA
		D2739	REV. C
			SHEET 1 OF 1
DATE		TITLE	SCALE
06.01.05		WEB	1:15
A	98.04.16	NEW ISSUE	
B	98.11.18	CHANGE HOLES FOR COMPATABILITY WITH AIRCRUISER FLOATS	
C	06.01.05	ADD/MOVE HOLES FOR COMPATABILITY W/APICAL FLOATS	

RELEASED
do 07/17DETAIL A

D2739 WEB

- 1) MATERIAL: MAKE FROM D2600-5 EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries